

ASAP



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBBP1425-103-05
Job Sheet 189672



Part No: RBBP1425-103-05

Job Qty: 50 pcs

Part Name: Guide

54 pcs.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 2/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBBP1425-101 Rev D IPP Rev A 18.03.13 New issue DP Verify DD/DWG RBBP1425-101 Rev D IPP Rev B 18.04.04 DWG update DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-154 - 1	50 pcs	2/1/19	2/1/19	0.00	12.50	SL-154 - 1		JB 19.02.01
120	QC 2	50 pcs	2/1/19	2/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		JB 19.02.01
							QC 2 - 63		

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Container No: S150210



Part: RBBP1425-103-05

Job No: 189672

Serial No/Batch: S150210

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 02/01/19

DAS
62
9-89

DAS
62
9-89

130	QC 8	50 pcs	2/1/19	0.00	0.00	QC 2 - 8	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 38	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	9mm-76 19/22/06
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
140	Packaging 3-1 - Stock - B4B	50 pcs	2/1/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	DAS 28 9-89
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
150	QC 21 - SA	50 pcs	2/1/19	0.00	0.00	QC 21 - SA - 21	

Part Op **110** - (MORI SL-154 LATHE) 1-Machine as per DWG. FB995 FOLIO REV: _____ DWG REV: _____ 2-
Descriptions: Deburr
120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
140 - (Identify as per dwg & Stock Location: _____)
150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.000	304 Round Bar 1.00	8.7000 ft (.174 ea)	110-SL-154 - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	M304R1.000	9	26	0

Part Specifications

Specifications could not be found.



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Job Sheet 189672



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Job Qty: 50 ea

Part Name: Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 2/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBBP1425-101 Rev D IPP Rev A 18.03.13 New issue DP Verify DD/DWG RBBP1425-101 Rev D IPP Rev B 18.04.04 DWG update DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		2/1/19	0.00	0.00	Start Up Machining-3		
110	CNC Lathe	50 pcs		2/1/19	0.00	12.50	SL-154		
120	QC	50 pcs		2/1/19	0.00	0.00	QC2 Machining-4		
130	QC	50 pcs		2/1/19	0.00	0.00	QC8 Machining-4		
140	Packaging	50 pcs		2/1/19	0.00	0.00	Packaging3-1		
150	QC21-SA	50 Ea		2/1/19	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FB995 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.000	304 Round Bar 1.00	8.7000 ft (.174 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R1.000	9	26	0

Part Specifications

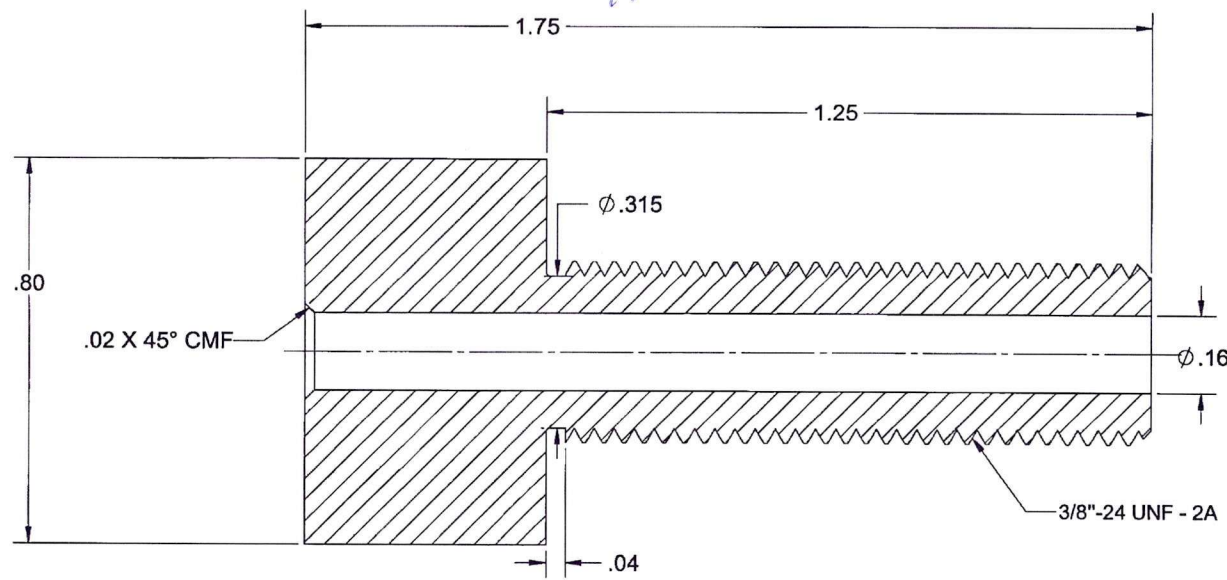
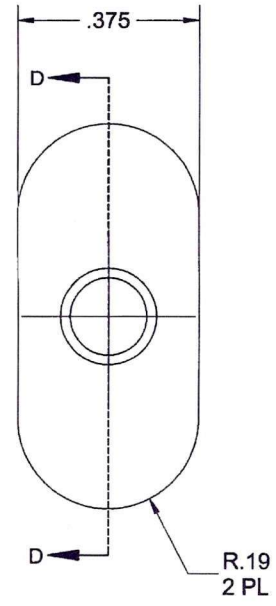
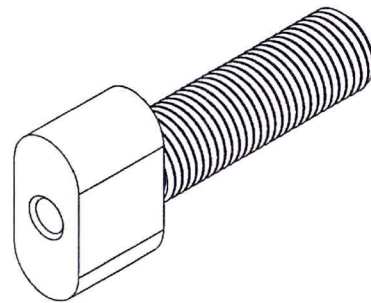
Specifications could not be found.

Plex 1/29/19 12:46 PM Dart.lajeunesse.marie

SL154

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
C	PART MADE IN 1 PIECE, -103-07 & -103-09 REMOVED, TEMPLATE UPDATED, MATERIAL UPDATED	17-647	18.1.23	VM	ML

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189672 MLJ
19-01-29



SECTION D-D

RBBP1425-103-05 GUIDE

- NOTES:
- 1) MATERIAL: AISI 303/304/316 SS
 - 2) FINISH: N/A
 - 3) HEAT TREAT: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A

DART AEROSPACE		Hawkesbury, Ontario, Canada	
GUIDE			
PART NO. RBBP1425-103-05		REV D	
TOOL NO. RBBP1425-103		INITIALS AND DATE	
DESIGNED BY: VM	1/23/2018	TOLERANCES:	
DRAWN BY: ML	03/20/2018	XXX ± .005	FRACTIONS ± 1/8
CHECKED BY: ML	03/20/2018	XX ± .01	ANGLES ± .5°
MFG REVIEW BY: DP	03/20/2018	X ± .1	SURFACE ROUGHNESS
APPROVED BY: ML	03/20/2018	SCALE: NTS	SHEET 6 OF 12
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
Other/Details:					

